

224 / 1230

Work Order ID 80246

80246

February-15-12 3:31:10 PM

Item ID: D3453-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Clevis

Start Date: 15/02/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 29/02/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: M.C.J

Date: 12/02/16

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3453 | Rev B | | | | | | | | |

100

0.00

100

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per Folio FA577

Rev:

Dwg D3453 Rev: B

2- Debur as per dwg D3453

SL 12-05-26

16

150

QC2- Inspect parts off machine FAI/FAIB

0.00

150

QC

Memo

0.00

Quality Control

SL 12-05-26

10

160

QC8- Inspect parts - second check

0.00

160

QC

Memo

0.00

Quality Control

SL 12/05/28

10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 80246

February-15-12 3:31:10 PM

80246

Page 2

Item ID: D3453-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clevis
 Start Date: 15/02/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 29/02/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 170 | Identify as per dwg & Stock Location: <u>WS</u> | 0.00 | | | | | | | |
| *170* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 180 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *180* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

4/4/28 (10)

12/5/29

ME 12-05-28

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

February-15-12 3:31:13 PM

Page 1

Work Order ID: 80246

80246

Parent Item: D3453-1

D3453-1

Parent Item Name: Clevis

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: A05.09.27New issueEC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304R1.250 | | Purchased | | | No | 100 | f | 24.7400 | 0.288 | 2.88 | | | |

M304R1 250

304 round bar 1.250

**

SL 12-05-26

Location

Loc Qty

Loc Code

MAT029

24.74

105872

12.33

108156

1.68

111018

10.73

6

24

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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|--|--|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 80246 |
| Description: Clevis | | Part Number: | D3453-1 |
| Inspection Dwg: D3453 Rev: B | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|--------------------------|------------------|--------|--------|----------------------|----------|
| Ø0.438 | +0.006/-0.001 | 442 | ✓ | | vern | SL-10 |
| R0.25 | +/-0.030 | 25 | ✓ | | | |
| 0.450 | +/-0.010 | 449 | ✓ | | | |
| 0.625 | +/-0.010 | 620 | ✓ | | HG | |
| 0.063 x 45° | +/-0.010 x 0.5° | 06x45° | ✓ | | vern | |
| Ø0.129 | +0.005/-0.001 | 129 | ✓ | | | |
| 3.26 | +/-0.030 | 3.260 | ✓ | | | |
| 1.00 | +/-0.030 | 998 | ✓ | | | |
| 1.550 | +/-0.010 | 1.550 | ✓ | | HG | |
| 0.500 | +0.010/-0.000 | 504 | ✓ | | | |
| 0.263 x 45° | +/-0.010 x 0.5° | 26x45° | ✓ | | | |
| R0.25 | +/-0.010 | 25 | ✓ | | | |
| | ±0.030 | | | | | |
| Ø1.13 | +0.012/-0.001 | 1.130 | ✓ | | | |
| Ø0.500 | +0.000/-0.005 | 499 | ✓ | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

| | | | |
|------------------------|--------------------------------|----------------------------|-----|
| Measured by: SK | Audited by: [Signature] | Prototype Approval: | N/A |
| Date: 12-05-26 | Date: 12/05/28 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--|------------|-------------|
| A | 06.06.30 | New Issue | KJ/JLM | |
| B | 07.01.17 | Dimensions added | KJ/JLM | |
| C | 08.10.09 | Diameter symbol removed from 0.500 dimension | KJ/DD | |
| D | 09.11.04 | Dimensions updated per Dwg Rev B | KJ | [Signature] |

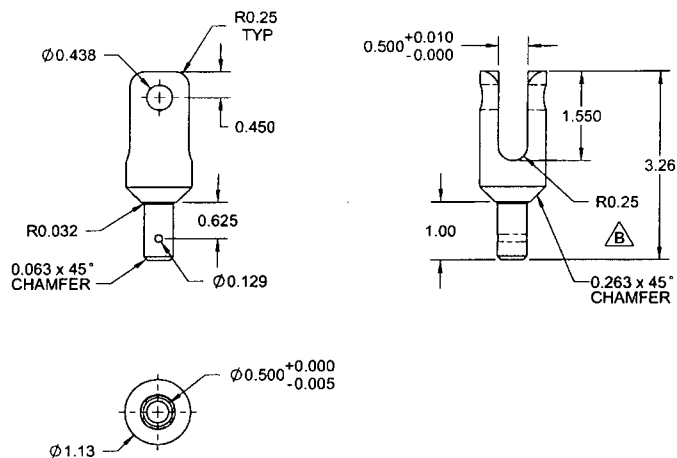
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

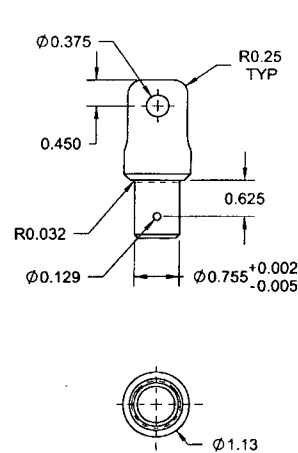
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



D3453-1 CLEVIS



D3453-3 CLEVIS

RELEASED
5/16/25/1110

D3453-1/3 NOTES:

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3453-1 = 0.41 lbs
D3453-3 = 0.41 lbs

80246-M.L.J
12/02/11

| B | DRAWING UPDATED TO CURRENT STANDARDS: R0.25 WAS 0.050 (ZN C5-1, C2-1); 1.220 WAS 1.175 (ZN D1-1); REF PAR 09-018 | RF | 09.05.21 |
|------------|--|----|----------|
| A | NEW ISSUE | RF | 05.09.02 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | RF | | |
| DRAWN | RF | | |
| CHECKED | RF | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 09.05.21 | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3453** REV. B
SHEET 1 OF 2

TITLE **CLEVIS** SCALE NTS

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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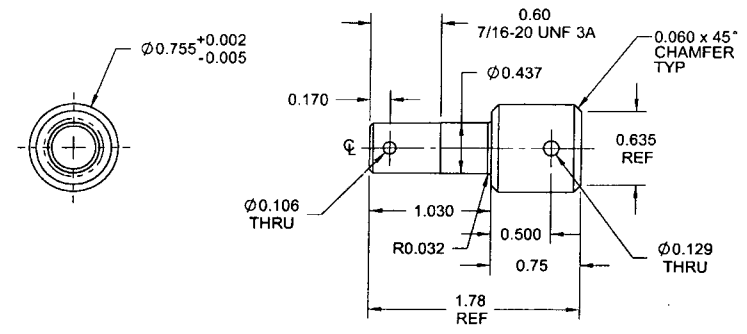
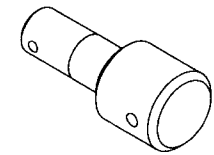
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

80246



D3453-5 PLUG

RELEASED
09/05/21

- D3453-5 NOTES:**
- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.13 lbs

| | | | |
|------------|----------|---|--------------|
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | CH | DRAWING NO. | REV. B |
| MFG. APPR. | | D3453 | SHEET 2 OF 2 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | CLEVIS | NTS |
| DATE | 09.05.21 | <small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD</small> | |

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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries